

January 13, 2016 11:16:03 AM

Need for orders to
ship Feb 11/16 Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Item Name: 429 Clamp Cushion

Start Date: 1/13/2016 **Start Qty:** 48.00

48

Cust Item ID:

Required Date: 1/27/2016 **Req'd Qty:** 48.00

48

Customer:

Reference:

Approvals: Process Plan: *SL* Date: 160113 Tooling:

Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4212	D	

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

0.22

1-Turn as per folio FA974 & dwg

FOLIO REV: NA

DWG REV: 0

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

48 ~~0~~ S.C. L. 16-01-21

48 J.C.-L, 16-01-71

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : _____							

Work Order ID 140665***140665***

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Item ID: D4212-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 429 Clamp Cushion

Start Date: 1/13/2016 Start Qty: 48.00

48

Cust Item ID:

Required Date: 1/27/2016 Req'd Qty: 48.00

48

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

(48)

16-01-26

DAS
9
9-89

130

Identify as per dwg & Stock Location: JFSYS

0.00

130

Packaging

Memo

0.01

Packaging

48

DAS
6
9-89

JAN 27 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.08

Quality Control

MCS

JAN 28 2016

MCS JAN 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

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Work Order ID: 140665

140665

Parent Item: D4212-1

D4212-1

Parent Item Name: 429 Clamp Cushion

Start Date: 1/13/2016

Required Date: 1/27/2016

Start Qty: 48.00

Required Qty: 48.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD IPP
REV:B 11.01.10 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No			100	f	30.6100	0.3708	18.73516			

D4287-1

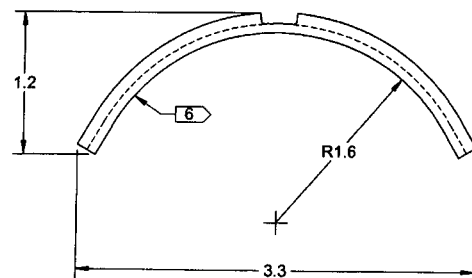
Uhmw U-Channel

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST479a	30.61	
135952	1.328	
138255	8.818	
138585	20.464	

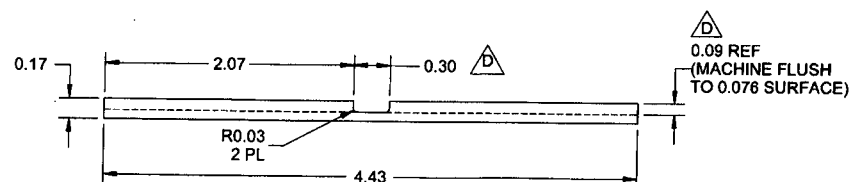
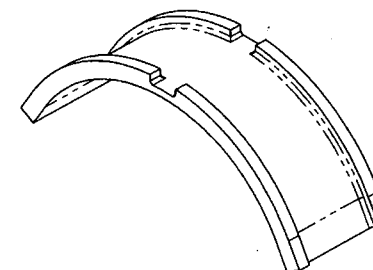
1,328 ft
8,818 ft
9,842 ft

19,988 ft

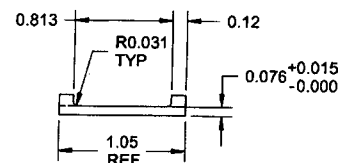
DAS
45
9-89
2016-01-15



D4212-1 CLAMP CUSHION
(MAKE FROM D4212-1F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)



D4212-1F FLAT MACHINED STATE 1



RELEASED
2015 MAY 22
A.R. ECN 15-567

- NOTES:**
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

20160113 *SM 140665*

D	ADD RETENTION SLOT, ADD COLD FORM NOTE, REFERENCE DIMENSIONS IN D4212-1 REASON: PAR 14-331, NCR 14-3521	VS	15.04.24
C	ADDED FLAT MACHINED STATE; CHANGED DIMENSIONS IAW MANUFACTURING PROCESS. REF: PAR10-29	MB	10.12.07
B	REDESIGN TO REDUCE COST: "CLAMP CUSHION" WAS "428 CLAMP CUSHION"; MAT'L WAS MUHMTWTR3.50DW XXXX (ZN A7-1)	MB	10.10.26
A	NEW ISSUE	MB	10.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS	DRAWING NO.	REV. D
CHECKED	RF	D4212	SHEET 1 OF 1
MFG. APPR.	JLM	TITLE	SCALE
APPROVED	HS	CLAMP CUSHION	NTS
DE APPR.	DST	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	15.04.24		

APPROVED

